



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5134-041
Job Sheet 197999



Part No: D5134-041

Job Qty: 6 pcs

Part Name: Damper Support Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/19/19

Job Tracking No:

Due Date: 8/30/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 14-09-09 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs	8/30/19	8/30/19	0.00	0.35	Bandsaw - 1		
110	HAAS 4 Axis - B4B	6 pcs	8/30/19	8/30/19	1.00	13.95	HAAS - 1 - B4B		SBZ 19/09/20
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		SBZ 19/09/20
							HAAS - 4 - B4B		
120	QC 2	6 pcs	8/30/19	8/30/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		SBZ 19/09/20
							QC 2 - 62		



Container No: S215607



Part: D5134-041

Job No: 197999

Serial No/Batch: S215607

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/20/19

130 QC 8	6 pcs	8/30/19	0.00	0.00	QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	20mm 19/09/22
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
135 Handfinish - 1-1 Chemical- B4B	6 pcs	8/30/19	0.00	0.40	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	

SEP 22 2019

SEP 23 2019

SEP 23

					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
137 QC 7	6 pcs	8/30/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	DAS 41 SEP 23 2019
					QC 7 - 47	9-89
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
140 Spray Paint - 2 - B4B	6 pcs	8/30/19	0.00	1.56	Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	RD 19-9-25
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
150 QC 14	6 pcs	8/30/19	0.00	0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	DAS 81 9-89
					QC 14 - 68	
					QC 14 - 40	OCT 02 2019
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
160 Small Fab - 2 - B4B	6 pcs	8/30/19	0.00	0.86	Small Fab - 1 - B4B	DAS 58 OCT 02 2019
					Small Fab - 2 - B4B	9-89
					Small Fab - 3 - B4B	

170 QC 5	6 pcs	8/30/19	0.00 0.00	Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	DAS
				QC 5 - 30	81
				QC 5 - 40	9-89
				QC 5 - 61	
				QC 5 - 81	
					OCT 03 2019
180 Packaging 3-1 - Stock - B4B	6 pcs	8/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	DAS
				Packaging 3 - 5 - B4B	74
				Packaging 3 - 6 - B4B	9-89
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
					OCT 04 2019

190 QC 21 - SA	6	8/30/19	0.00	0.00	QC 21 - SA - 21	DAS 21 OCT 04 2019
	pcs				QC 21 - SA - 70	9-89
					QC 21 - SA - 53	

Part Op 100 - Bandsaw - CUT BLANK TO 5.125" LONG *****CHECK GRAIN DIRECTION*****
 Descriptions: 110 - HAAS CNC Vertical Machine - Mill as per Dwg and folio FB342
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 135 - Chemical Conversion Coat per QSI005 4.1
 137 - QC7-Inspect Chemical Conversion Coat
 140 - Spray Paint / NDT Room ***MASK BEARING HOLE AS PER NOTE 2*** PRIME AS PER DWG AND QSI
 BATCH: 5195271 PAINT AS PER DWG AND QSI BATCH: 5204428
 150 - QC14- Inspect Spray Paint
 160 - Small Fab - install bushings as per dwg
 170 - QC5- Inspect part completeness to step on W/O
 180 - Identify as per dwg & Stock Location: _____ -LOCATION : LG054
 190 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B3.000X4.000	7075-T73 Bar 3.0 X 4.0 Grain Direction Along 3"	2.5620 ft (.427 ea)	100-Bandsaw - 1	FM138252 x 1
NAS77C6-021	Bushing	12 Ea (2 ea)	160-Small Fab - 2 - B4B	506663 x 5 FM134833

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T73B3.000X4.000	3	3	0
160-Small Fab - 2 - B4B	NAS77C6-021	12	191	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Damper Support Assembly, LH	0.360Inches $\pm$ 0.030	0.390 0.330		.359
2	Damper Support Assembly, LH	0.188Inches $\pm$ 0.005 - 0.001	0.193 0.187		.188
3	Damper Support Assembly, LH	0.257Inches $\pm$ 0.006 - 0.001	0.263 0.256		.257
4	Damper Support Assembly, LH	1.932Inches $\pm$ 0.010	1.942 1.922		1.932
5	Damper Support Assembly, LH	0.632Inches $\pm$ 0.010	0.642 0.622		.636
6	Damper Support Assembly, LH	0.632Inches $\pm$ 0.010	0.642 0.622		.636
7	Damper Support Assembly, LH	0.730Inches $\pm$ 0.010	0.740 0.720		.730
8	Damper Support Assembly, LH	0.500Inches $\pm$ 0.000 - 0.010	0.500 0.490		.4995
9	Damper Support Assembly, LH	0.100Inches $\pm$ 0.010	0.110 0.090		.100
10	Damper Support Assembly, LH	0.728Inches $\pm$ 0.010	0.738 0.718		.728
11	Damper Support Assembly, LH	0.250Inches $\pm$ 0.030	0.280 0.220	Radius	
12	Damper Support Assembly, LH	0.630Inches $\pm$ 0.030	0.660 0.600	Radius	
13	Damper Support Assembly, LH	0.063Inches $\pm$ 0.010	0.073 0.053	Radius	
14	Damper Support Assembly, LH	0.117Inches $\pm$ 0.010	0.127 0.107		.118
15	Damper Support Assembly, LH	0.177Inches $\pm$ 0.010	0.187 0.167		.180
16	Damper Support Assembly, LH	0.841Inches $\pm$ 0.010	0.851 0.831		.828 , 841
17	Damper Support Assembly, LH	0.208Inches $\pm$ 0.010	0.218 0.198		.209
18	Damper Support Assembly, LH	0.208Inches $\pm$ 0.010	0.218 0.198		.207
19	Damper Support Assembly, LH	0.860Inches $\pm$ 0.010	0.870 0.850		.860
20	Damper Support Assembly, LH	1.471Inches $\pm$ 0.010	1.481 1.461		1.472
21	Damper Support Assembly, LH	0.130Inches $\pm$ 0.030	0.160 0.100	Radius	.130

Plex 7/19/19 1:01 PM dart.lacelle.linda